



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-251
Job Sheet 191907



Part No: D135-1027-251

Job Qty: 1 pcs

Part Name: Std Height Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/19

Job Tracking No:

Due Date: 3/22/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D135-1027-251 REV.D IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 17.12.14 AS PER DWG
REV.C DD VERF:JFS IPP REV:C 18.11.09 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Handfinish - 1 - Chemical	1 pcs	3/22/19		0.00	0.17	Handfinish - 1 - 1	
							Handfinish - 1 - 2	
							Handfinish - 1 - 3	
							Handfinish - 1 - 4	
							Handfinish - 1 - 5	
							Handfinish - 1 - 6	
							Handfinish - 1 - 7	
							Handfinish - 1 - 8	
							Handfinish - 1 - 9	
							Handfinish - 1 - 10	
							Handfinish - 1 - 11	
							Handfinish - 1 - 12	
							Handfinish - 1 - 13	
							Handfinish - 1 - 14	
							Handfinish - 1 - 15	
							Handfinish - 1 - 16	
							Handfinish - 1 - 17	
							Handfinish - 1 - 18	
							Handfinish - 1 - 19	
							Handfinish - 1 - 20	
							Handfinish - 1 - 21	
							Handfinish - 1 - 22	
105	QC 7	1 pcs	3/22/19		0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	



Container No: S164524



Part: D135 - 1027 - 251

Job No: 191907

Serial No/Batch: S164524

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 03/21/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DAS
10
9.39

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
110	Purchasing	1 pcs	3/22/19	0.00 0.00	Purchasing - 1	03/21/2019 PC
	Outsource 23				Purchasing - 2	
					Purchasing - 3	
120	Packaging 2-1 - Receive - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130	QC 6	1 pcs	3/22/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	AD 19-03-27

132	Crosstubes - 2 - B4B	1 pcs	3/22/19	0.00 1.00	QC 6 - 68	
					QC 6 - 61	
					Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	GP 19-07-04.
					Crosstubes - 3 - B4B	
135	QC 6	1 pcs	3/22/19	0.00 0.00	Crosstubes - 4 - B4B	
					QC 15 - 12	
					QC 15 - 3	
					QC 15 - 47	DAS
					QC 15 - 49	40
140	Outsource	1 pcs	3/22/19	0.00 0.00	QC 15 - 58	JUL 09 2019 9-89
					QC 15 - 9	
					SKY002-VC	5
					Packaging 2 - 1 - B4B	2019-07-19
					Packaging 2 - 2 - B4B	
150	Packaging 2-2 - Receive - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 6	1 pcs	3/22/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	JUL 19 2019
					QC 6 - 61	DAS 40 9-89
170	Packaging 3-1 - Stock - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	A8 19-7-19
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - FG	1 pcs	3/22/19	0.00 0.00	QC 21 - FG - 21	DAS 21 JUL 22 2019
				QC 21 - FG - 70	9-89
				QC 21 - FG - 53	

Part Op **100** - (Chemical Conversion Coat per QSI005 4.1) Alodine prior to sending the extrusion to an outside vendor.
 Descriptions: **105** - (QC7-Inspect Chemical Conversion Coat)
110 - Issue P/O to Tube Caron: _____ Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material release note is attached
130 - (QC6- All purchased or subcontracted products)
132 - (Crosstube Grinding Booth) REMOVE ALL MARK AS PER DWG
135 - (QC15- Crosstube Dimensional Check)
140 - ISSUE P/O: _____ C OF C IS REQUIRED
150 - (Receive & Inspect for Damage & Mat'l Certs) OF C IS REQUIRED
160 - (QC6- All purchased or subcontracted products)
170 - (Identify as per dwg & Stock Location: LG050)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6026-110	Crosstube Material	1 Ea (1 ea)	100-Handfinish - 1 - Chemical	
D135-1027-251P	Std Height Aft Crosstube	1 pcs (1 ea)	120-Packaging 2-1 - Receive - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Handfinish - 1 - Chemical	D6026-110	1	24	0
120-Packaging 2-1 - Receive - B4B	D135-1027-251P	1	6	0

Part Specifications
Specifications could not be found.

Plex 3/15/19 3:42 PM Dart.Hadley.Shannon



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Hawkesbury, ON
K6A 1K7
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Fax 613 632-5246

D135-1027-251
Job Sheet 191907



Part No: D135-1027-251

Job Qty: 1 ea

Part Name: Std Height Aft Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/19

Job Tracking No:

Due Date: 3/22/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D135-1027-251 REV.D IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 17.12.14 AS PER DWG
REV.C DD VERF:JFS IPP REV:C 18.11.09 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/22/19	0.00	0.00	Start Up Handfinish		
100	HandFinish	1 pcs		3/22/19	0.00	0.17	HandFinish1		
105	QC	1 pcs		3/22/19	0.00	0.00	QC7-5		
110	Purchasing	1 pcs		3/22/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
120	Packaging	1 pcs		3/22/19	0.00	0.00	Packaging2		
130	QC	1 pcs		3/22/19	0.00	0.00	QC6		
132	Crosstubes	1 pcs		3/22/19	0.00	1.00	Crosstube Grinding Booth		
135	QC	1 pcs		3/22/19	0.00	0.00	QC15		
140	Outsource	1 pcs		3/22/19			SKY002-VC	5	
150	Packaging	1 pcs		3/22/19	0.00	0.00	Packaging2		
160	QC	1 pcs		3/22/19	0.00	0.00	QC6		
170	Packaging	1 pcs		3/22/19	0.00	0.00	Packaging3-1		
180	QC21-FG	1 Ea		3/22/19	0.00	0.00	QC21		

Part Op 100 - Alodine prior to sending the extrusion to an outside vendor.

Descriptions: 110 - Issue P/O to Tube Caron: 042567 Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required

120 - Ensure material release note is attached

132 - REMOVE ALL MARK AS PER DWG

140 - ISSUE P/O: _____ C OF C IS REQUIRED

150 - C OF C IS REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6026-110	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	<u>5152384</u>
D135-1027-251P	Std Height Aft Crosstube	1 pcs (1 ea)	120-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6026-110	1	24	0
120-Packaging	D135-1027-251P	1	6	0
Part Specifications				
Specifications could not be found.				

Plex 3/12/19 9:09 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Supplier: TUB001-VC
Tube Caron Inc.
99 Louis-Joseph-Doucet Street
Lanoraie
QC
JOK 1EO Canada
Phone: 450-887-2766
Fax: 450-887-2897

PO No: PO042567
PO Date: 2/11/19
Due Date: 3/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190567	D135-1027-253	Mid Height Aft Crosstube (Purchasing) Issue P/O to Tube Caron: Manufacture D135-1027-253 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6027-115** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

IX MAR 21 2019

Line Item Note

REV C											
190568	IX	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190569	IX	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191900	IX	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191901	IX	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5		\$1,500.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	190489	D135-1027-251	Std Height Aft Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

1X MAR 21 2019

Line Item Note REV D

190571	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190572	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191903	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191905	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191907	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:						6	0	6		\$1,800.00



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K6A 1K7
Canada

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PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190560	D135-1027-153	Mid Height Fwd Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
1 X MAR 21 2019											
Line Item Note REV B											
	190562	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	190564	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191909	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191910	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5		\$1,500.00



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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	190575	D135-1027-151	Std Height Fwd Crosstube Purchasing - Issue P/O to Tube Caron: Manufacture D135-1027-151 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note REV D											
	190576			Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191908			Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							3	0	3		\$900.00

Grand Total: \$5,700.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/21/19 12:52 PM dart.Lussier.Patrick



SHIPPING BILL

BOL 14944

13/03/2019

Tube Caron Inc.

99 Louis-Joseph-Doucet
Lanoraie, QC, Canada
J0K 1E0
Phone: 450-887-2766

Fax: 450-887-2897

Ship To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-1053

Fax : 613-632-4443

Sold To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-5200

Fax : 613-632-4443

Third Party Billing:

Ln	Item	Qty	Po	Job	Weight	UOM
1	PALETTE	1			20.00	Pounds
	D135-1027-151 REV D	1	✓ PO042567	J21867-11	13.36	Pounds
	D135-1027-151 REV D	1	✓ PO042567	J21867-12	13.36	Pounds
	D135-1027-151 REV D	1	✓ PO042567	J21867-16	13.36	Pounds
	D135-1027-153 REV B	1	✓ PO042567	J21867-10	14.57	Pounds
	D135-1027-153 REV B	2	✓ PO042567	J21867-15	29.14	Pounds
	D135-1027-153 REV B	1	✓ PO042567	J21867-8	14.57	Pounds
	D135-1027-153 REV B	1	✓ PO042567	J21867-9	14.57	Pounds
	D135-1027-251 REV D	1	✓ PO042567	J21867-5	16.21	Pounds
	D135-1027-251 REV D	1	✓ PO042567	J21867-6	16.21	Pounds
2	PALETTE	1			20.00	Pounds
	D135-1027-251 REV D	3	✓ PO042567	J21867-14	48.64	Pounds
	D135-1027-251 REV D	1	✓ PO042567	J21867-7	16.21	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-1	19.81	Pounds
	D135-1027-253 REV C	2	✓ PO042567	J21867-13	39.62	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-2	19.81	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-3	19.81	Pounds
	D135-1027-253 REV C	1	✓ PO042567	J21867-4	19.81	Pounds

Carrier:

Phone:

Way Bill:

Journey Freight

1-888-633-1252 #3221

Fob:

Freight Charges:

Fob Lanoraie

Collect

Total Of Packages :

2 PALETTES

96 X 32 X 36

96 X 32 X 36

Carrier : Journey Freight

Total Weight:

369.06 #

Shipper : Tube Caron Inc.

Declared Value :

(No Additional Insurance Required)

Not Applicable For Insurance Purposes

14-03-2019

CERTIFICATE OF CONFORMANCE

CUSTOMER : Dart Aerospace

DATE : March 21, 2019

P.O.# PO042567

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

PART NO.	QTY.	DRAWING NO. / REV.
D135-1027-253 ✓ MID HEIGHT AFT XTUBE	6 ✓	D135-1027-253 / REV.C
D135-1027-153 ✓ MID HEIGHT FWD XTUBE	5 ✓	D135-1027-153 / REV.B
D135-1027-151 ✓ STD HEIGHT FWD XTUBE	3 ✓	D135-1027-151 / REV.D
D135-1027-251 ✓ STD HEIGHT AFT XTUBE	6 ✓ <i>PD 19-03-27</i>	D135-1027-153 / REV.D

Sincerely,

Kevin Gadoury

Kevin Gadoury

DART AEROSPACE LTD		Work Order: 191907
Description: STD HEIGHT AFT CROSSTUBE		Part Number: D135-1027-251
Inspection Dwg: D135-1027-251 Rev: C		Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700" TYP	+/-0.005"	2.705	1		VSC-01	
7.07" TYP	+/-0.030"	7.076	1			
2.17" REF	+/-0.030"	2.178	1			
3.13" TYP	+/-0.030"	3.134	1			
Ø.194" THUR 2PL	+0.006" -0.001"	Ø.195	1			
Ø.194" THUR	+0.006" -0.001"	Ø.196	1			
17.0" 2PL	+/-0.100"	17.009	1			
Ø.313" THUR 4PL	+0.006" -0.001"	Ø.316	1			
Ø.670" THUR 2PL	+0.006" -0.001"	Ø.677	1			

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.177"	0.181	0.179	0.175	0.181				
21"	0.177"	0.182	0.174	0.172	0.179				
21"	0.177"	0.181	0.182	0.176	0.177				
CENTER OF BEND	0.177"	0.170	0.174	0.180	0.176				
CENTER OF BEND	0.177"	0.172	0.173	0.181	0.180				

OUTSIDE DIAMETER MEASUREMENTS

LOCATION	DWG DIM	M1	M2				
CL	3.543"						
CENTER OF BEND	3.543"						
CENTER OF BEND	3.543"						

CRUSHING

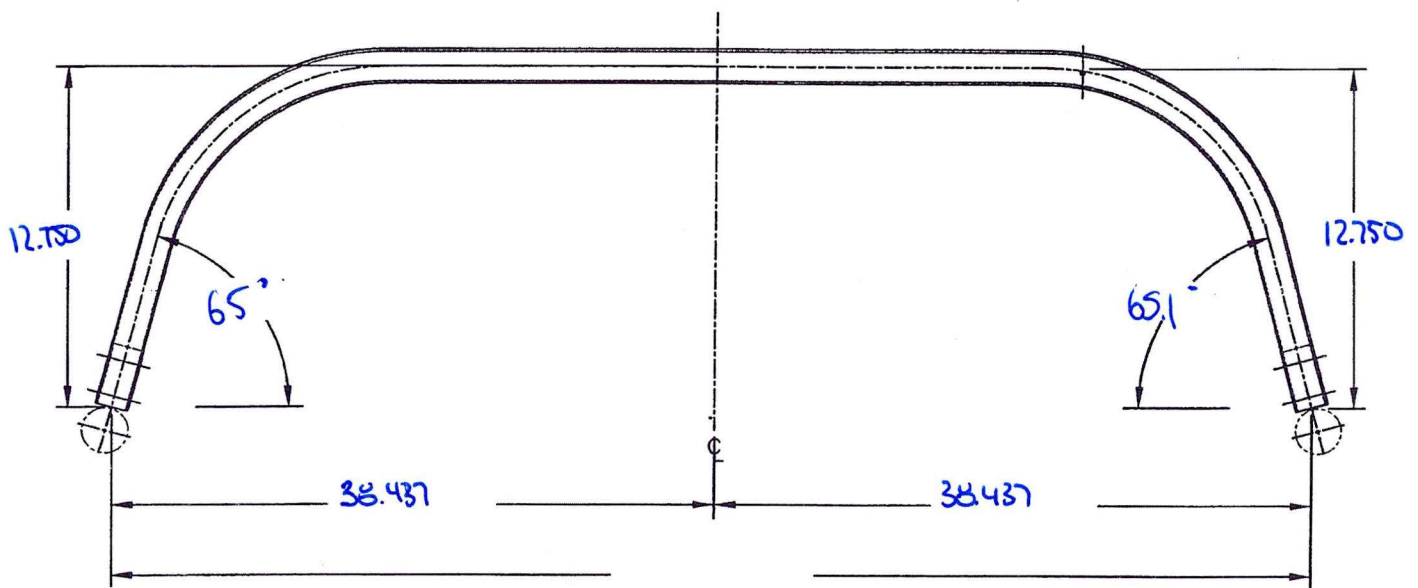
	SIDE A	SIDE B
MAX 2%	.14%	.04%

TWIST

	SIDE A	SIDE B
MAX 0.25"		

DART AEROSPACE LTD		Work Order: 191907
Description: STD HEIGHT AFT CROSSTUBE		Part Number: D135-1027-251
Inspection Dwg: D135-1027-251 Rev: C		Page 2 of 2

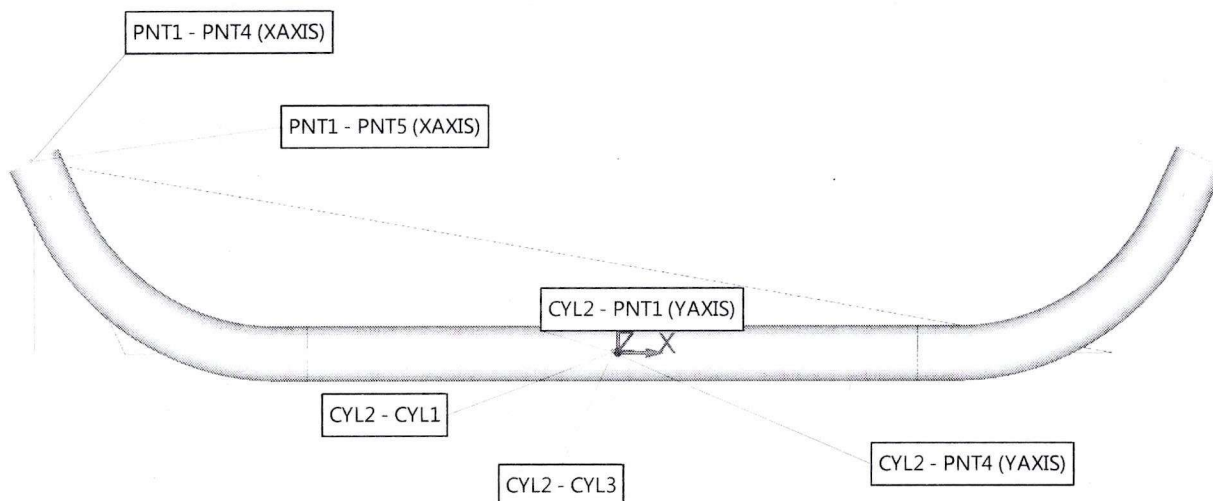
Required Dimension	Min	Max
Height	12.62"	12.88"
1/2 Span	38.35"	38.61"
Angle	64°	66°
Total Span	76.70"	77.22"
Bending Passes		
Crushing	0%	2%



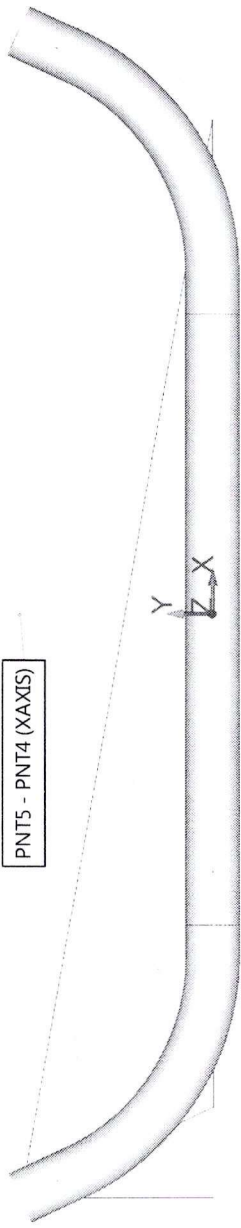
Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	



pcodmis		PART NAME : D135-1027-251_Plage+Coupe				mars 09, 2019		15:52	
		REV NUMBER : Rev.C		SER NUMBER : S164524		STATS COUNT : 1			
∠	DEG	ANGL1 - CYL2 TO CYL1							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	-64.9925	0.5000	0.5000	-64.8135	0.1790	0.0000			
∠	DEG	ANGL2 - CYL2 TO CYL3							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	64.9925	0.5000	0.5000	65.1610	0.1685	0.0000			
↔	IN	DIST1 - PNT1 TO PNT4 (XAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	76.9610	0.2500	0.2500	76.9845	0.0235	0.0000			
↔	IN	DIST2 - CYL2 TO PNT1 (YAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	12.7469	0.1300	0.1300	12.6995	-0.0474	0.0000			
↔	IN	DIST3 - CYL2 TO PNT4 (YAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	12.7469	0.1300	0.1300	12.7335	-0.0134	0.0000			
↔	IN	DIST4 - PNT1 TO PNT5 (XAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	38.4805	0.1300	0.1300	38.4922	0.0117	0.0000			



		DIST5 - PNT5 TO PNT4 (XAXIS)				
↕	IN	NOMINAL	+TOL	-TOL	MEAS	DEV
AX						
M		38.4805	0.1300	0.1300	38.4922	0.0117
						0.0000



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044044



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044044

PO Date: 7/18/19

Due Date: 7/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	190568	D135-1027-253	Mid Height Aft Crosstube - DO NOT USE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	190569		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
②	191905	D135-1027-251	Std Height Aft Crosstube - DO NOT USE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	191907		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
③	190576	D135-1027-151	Std Height Fwd Crosstube - DO NOT USE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	190575		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00

DAS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044044



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194644	D412-664-203	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	194647		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196270		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196271		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							4	0	4		\$478.00

Grand Total: \$1,195.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 1:28 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41122	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044044 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

- ✓ 4 AFT CROSSTUBES , P/N: D412-664-203 , J/S: 194644 , 194647 , 196270 , 196271
- ✓ 2 STD HEIGHT FWD CROSSTUBES , P/N: D135-1027-151 , J/S: 190575 , 190576
- ✓ 2 STD HEIGHT AFT CROSSTUBES , P/N: D135-1027-251 , J/S# 191905 , 191907
- ✓ 2 MID HEIGHT AFT CROSSTUBES , P/N: D135-1027-253 , J/S: 190568 , 190569

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9-89

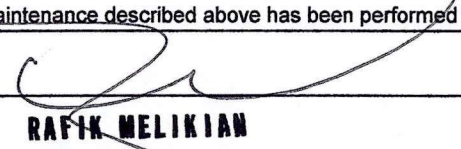
Action Taken:					Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142					JUL 19 2019	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

RECEIVED

JUL 19 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JUL 19 2019
Name: RAFIK MELIKIAN		